

Work Order ID 74070

Wednesday, September 21, 2011 10:29:55 A



Page 1

Item ID: D350-589-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Side Door Latch Modification

Start Date: 9/21/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 9/30/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10/9/21

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

INN-D350-589

E

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type label as per PPP D350-589-011 CHG002

W 11 - 11 - 02 4
for BG 11-9-22

105

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

90 11-09-22

110

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

W 11 - 11 - 02 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D350-589-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Side Door Latch Modification

Start Date: 9/21/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 9/30/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Packaging	0.00							
	Packaging								
	Memo	0.00							
	Identify and pack for shipping as per QSI 014								
130	QC21 - Final Inspection - Work Order Release	0.00							
	QC								
	Memo	0.00							
	Quality Control								

Run 11/2 (4)

11/11/02

ME 11-11-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, September 21, 2011 10:30:01 AM

Page 1

Work Order ID: 74070

Parent Item: D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 9/21/2011

Required Date: 9/30/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP F 02.08.29 Removed D2587 Plug KJ
ALL AT CHANGE 002

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD10 Washer	NAS1149D0363J	Purchased	No			105	Each	0.0000	3	12			
D2237 Striker Plate		Manufactured	No			105	Each	55.0000	3	12			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST009				55					
					66139			2					
					73702			53					
D2583 Latch Bracket		Manufactured	No			105	Each	5.0000	3	12			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST017				5					
					70559			5					
D2585 Mounting Channel		Manufactured	No			105	Each	64.0000	3	12			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST017				64					
					70814			9					
					73297			55					

SP 11-09-22
B 74073 Fx

SP 11-09-22

Fx
Fx

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

Wednesday, September 21, 2011 10:30:01 AM

Page 2

Work Order ID: 74070

Parent Item: D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 9/21/2011

Required Date: 9/30/2011

Start Qty: 4.00

Required Qty: 4.00

D2586

Manufactured No

105

Each

27.0000

3

12

Door Latch

Location

Loc Qty

Loc Code

ST204

27

70557

27

105

Each

6.0000

D2587

Manufactured No

Door Slug, 350 Hinge

Location

Loc Qty

Loc Code

ST017

6

66836

6

105

Each

62.0000

D2589

Manufactured No

Keys, Key Chain, 350 Hinge

Location

Loc Qty

Loc Code

ST018

62

58194

62

105

Each

2,736.000

MS20470AD4-5

Purchased No

Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

2736

118405

2736

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Wednesday, September 21, 2011 10:30:01 AM

Work Order ID: 74070

Parent Item: D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 9/21/2011

Required Date: 9/30/2011

Start Qty: 4.00

Required Qty: 4.00

MS21042113

Purchased

No

105

Each

2,592.000

3

12



Nut

Location

Loc Qty

Loc Code

ST300

2592

117441

24

117601

363

117885

205

118451

1000

118927

1000

MS270391-15

Purchased

No

105

Each

90.0000

3

12



Screw

Location

Loc Qty

Loc Code

ST292

90

118093

25

118574

65

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

52.4 PARTS LIST

589 -011	589 -041	589 -042	589 -043	Part Number	Description
X				D350-589-011	SIDE DOOR LATCH MODIFICATION KIT
	X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
		X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
			X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
	1			D2991-1	Door
		1		D2991-2	Door
			1	D2991-3	Door
3	3	3	3	D2237	Striker Plate
	1	1	1	D2464-1700	Seal
3				D2583	Latch Bracket
3	3	3	3	D2585	Latch Clamp
3	3	3	3	D2586	Latch J
1				D2587	Plug
1	1	1	1	D2589	Keys, Key Chain
	3	3	3	D2621	Latch Plate
	2**	2**	2**	D2992-1	Doubler
	1	1	1	D3085-041	Prop Assembly
	1*	1*	1*	D3015-3	Locknut
	1*	1*	1*	D3081-1	Prop Hinge
	1*	1*	1*	D3082-1	Clip
	1*	1*	1*	D3084-1	Prop Arm
	1*	1*	1*	AN4-5A	Bolt
	3*	3*	3*	AN960JD10	Washer
	3*	3*	3*	AN960JD10L	Washer
	2*	2*	2*	AN960JD416	Washer
	1*	1*	1*	AN960JD516L	Washer
	3*	3*	3*	MS21042L3	Nut (or MS21042-3)
	1*	1*	1*	MS21042L4	Nut (or MS21042-4)
	3*	3*	3*	MS27039-1-13	Screw
	1*	1*	1*	SL69-BS	Ball Stud
	6	6	6	AN3-4A	Bolt
3	3	3	3	AN960JD10	Washer
3	9	9	9	MS21042L3	Nut (or MS21042-3)
6	6	6	6	MS20470AD4-5	Rivet
3	3	3	3	MS27039-1-15	Screw

* Reference only. Included in D3085-041 Prop Assembly listed above.

** Reference only. Included in D2991-1/-2/-3 Doors listed above.